Date:

Monday, 15/12/2008 2:01:40 PM

User:

Julie Dawson

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**  : 44086 : 10316

P.O. Number

This Issue

: 15/12/2008

: NC

Prsht Rev. First Issue **Previous Run** 

: 11

: 34599

Type

S.O. No. :

: SMALL /MED FAB

Part Number

**Drawing Name** 

: D2680041

: NUT PLATE

**Drawing Number** 

: D2680 REV B1

Project Number **Drawing Revision**  : N/A : B1

Material

**Due Date** 

: 22/12/2008

Qty:

50 Um:

Each

Written By

Checked & Approved By

Comment

Added Steps 2-4, 7-8 KJ/JLM Now on WaterJet 06-10-12 JLM Est Rev:E

est rev F

QC5 after c'sink 07.07.05 EC

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M1010S16GA

1010/1025 sheet 16GA



Comment: Qty.:

0.0138 sf(s)/Unit

Total: 0.6878 sf(s)

1010/1025/A21/6aA SHEET .063" thk

Batch:

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2680

Dwg Rev:\_\_\_ Prog Rev:\_

8 r 6 r 8 EN



2-Deburr if necessary

3.0

QC2



B 8-12-18

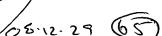


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK





Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2-C'sink as per Dwg D2680



W/O:				W	ORK ORDER CHANC	GES				
DATE	STEP		PROC	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	D269	80-04) P/	4 (4 :# RA	_ Fault Ca	tegory:	NCR: Yes	No DQ	 A:	Date: <u></u>	99.01.30
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NCR: 4	1086		W	ORK OR	DER NON-CONFORM	ANCE (NC	R)		,	
		Description o		Corrective Action Section B			Verifi	cation	Approval	Approval
DATE	STEP			Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	ion C	Chief Eng	QC Inspecto
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Monday, 15/12/2008 2:01:40 PM Date: Julie Dawson User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: NUT PLATE** Job Number: 44086 Part Number: D2680041 Job Number: Seq. #: Description: Machine Or Operation: INSPECT WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING 7.0 Comment: POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3 START TIME: OVEN TEMPERATURE: FINISH TIME: INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 MS20426AD33 Rivet Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s) Pick: Part Number Description Batch Qty 11563 2 MS20426AD3-3 Rivet Nutplate MS21069L4 10.0 1.0000 Each(s)/Unit Total: 50.0000 Each(s) Comment: Qty.: Pick: Part Number Description Batch Qty MS21069L4 Nut Plate 1 SMALL FAB 1 11.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Install Nut Plate as per Dwg D2680 INSPECT WORK TO CURRENT STEP QC5 12.0 Comment: INSPECT WORK TO CURRENT STEP

Dart Aerospac	e Ltd
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W/O:		WORK ORDER CHANGES												
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Date: Monday, 15/12/2008 2:01:40 PM User: Julie Dawson **Process Sheet** Drawing Name: NUT PLATE Customer: CU-DAR001 Dart Helicopters Services Job Number: 44086 Part Number: D2680041 Job Number: Seq. #: **Machine Or Operation:** Description: PACKAGING 1 PACKAGING RESOURCE #1 13.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTIONW/O RELEASE QC21 14.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES										
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DART AEROSPACE LTD	Work Order: JULOSTO
	7/030
Description: Nut Plate	Part Number: D2680-1
Inspection Dwg: D2680 Rev: B1	Page 1 of 1

	FIR	RST	ARTICLE II	NSPECTI	ON CHI	ECKLIST		
		X	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance		Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
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Ø0.266	+0.006/-0.00	1	806,	×				
Ø0.136	+0.005/-0.00	1	,138	8				
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0.280	+/-0.010		086,	X.				
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Measured by:	B		Audited by:	1		Prototype Ap	proval:	N/A
Date:	8-12-18		Date:	108.12	.29		Date:	N/A
Deta Deta	Change	-	-	/		- In	oviced by	Annanada

Rev	Date	Change		Revised by	Approv <b>∉</b> d
Α	07.05.31	New Issue	P/O D2680-041	KJ/JLM of	
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## **Dart Aerospace Ltd**

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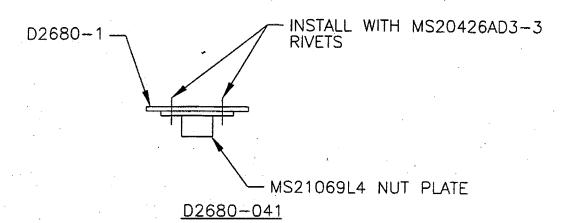


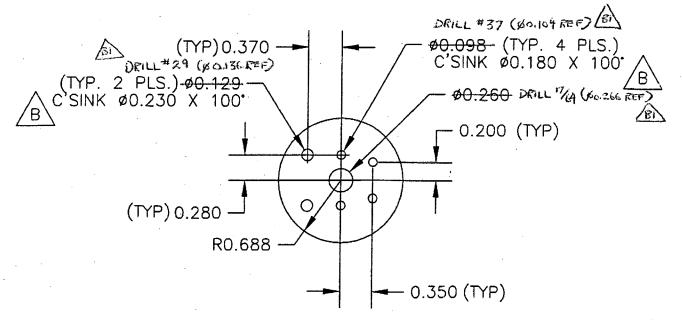


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DESIG	<b>}</b>	DRAWN BY	DART AEROSPACE USA, INC.
CHEC	KED	APPROYED	DRAWING NO. REV. B
	$\varphi$	KE	D2680 SHEET 1 OF 1
DATE	····		TITLE SCALE
98.1	12.14		NUT PLATE
Α	2	97.09.15	NEW ISSUE
В		98.12.14	CHANGE C'SINKS (PER TSR A1041)
t	6.11		



DATE		TITLE S	CALE
98.1	12.14	NUT PLATE	1:1
Α	97.09.1	NEW ISSUE	i.
8	98.12.1	CHANGE C'SINKS (PER TSR A1041)	
 81	4-11.0	CHANGE HOLES & FINISH	





ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL MATERIAL: 0.063 THICK (16 GAUGE).

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

SHOP COPY TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PER DART QUART 
BI) POWDER COAT WHITE (4.35.2) PER DART WI OUS 4.3

## Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES											
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